

# Work Order ID 53110

October 22, 2009 8:58:08 AM



Page 1

Item ID: DSI 9342-011

Accept



Setup Start



Revision ID: B

Stop



Item Name: Gusset Repair

Start Date: 22/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date: 09-10-22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9342

B

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP DSI 9342-011  
CHG001

0.00

*809/10/29*

*HJ for BG 09/10/29*

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

*69/10/29 (2)*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

*2) 809/10/29*

*(XU) /*

**Work Order ID 53110**

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Page 2

Item ID: DSI 9342-011

Accept

Revision ID: B

Item Name: Gusset Repair

Start Date: 22/10/2009 Start Qty: 4.00

Required Date: 30/10/2009 Req'd Qty: 4.00



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 		0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9342-011 Location: <u>A</u> PPP rev: <u>A</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

9/10/09 9250

09/11/02

MF 09-10-30

# Picklist Print

October 22, 2009 8:58:12 AM

Page 1

Work Order ID: 53110

Parent Item: DSI 9342-011RevA

Parent Item Name: Gusset Repair

Comments:

Start Date: 22/10/2009

Required Date: 30/10/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3929-041RevA 2P Manufactured No



Gusset Assembly

110

Each

7.0000

8.0000



52831 2X

239

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

7

47273

1

51439

6

51439 6K

D3929-042RevA 2P Manufactured No



Gusset Assembly

110

Each

6.0000

8.0000



52835 5X

29/10/09

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

6

50567

2

50869

1

51137

3

51137 3X

# Picklist Print

Page 2

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Work Order ID: 53110

Parent Item: DSI 9342-011RevA

Parent Item Name: Gusset Repair

Start Date: 22/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-15A 4P  
Bolt

Purchased No 110 Each 180.0000 16.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	180	
107737	8	
108077	1	
108868	7	
109148	18	
110399	8	
111295	138	

AN960JD416 8X  
Washer

Purchased No 110 Each 4,785.000 32.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	4785	
108161	521	
110523	340	
111279	101	
111916	482	
112314	3341	
16941	0	

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Shop Packet Print

Page 2

# Picklist Print

Page 3

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Work Order ID: 53110

Parent Item: DSI 9342-011RevA

Parent Item Name: Gusset Repair

Start Date: 22/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L4	44	Purchased	No			110	Each	6,008.000	16.0000	✓		
-----------	----	-----------	----	--	--	-----	------	-----------	---------	---	--	--



Nut

10/22/09 (4)

Warehouse	Loc Qty	Loc Code
Main Warehouse		
ST	6008	
110507	184	
111827	5815	
112314	9	
15924	0	

111827

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BA 09-10-22

## DART SERVICE INSTRUCTION

TO AMEND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607

REF. CANADIAN STC: SH94-14

REF. FAA STC: SR00213NY

REF. EASA STC: EASA.IM.R.S.01405

IN CASES WHERE THE D2325 GUSSETS HAVE SUSTAINED CONSIDERABLE DAMAGE, DSI 9342-011/-013 REPAIR KITS CAN BE PROCURED FROM DART TO REWORK EXISTING D350-607-041/-043 BASKET BASES ONLY. D350-607-045/-047 BASKET BASES CANNOT BE REWORKED TO THIS PROCEDURE. REPLACE THE D2325 GUSSETS BY T.I.G. WELDING AS FOLLOWS:

- 1) CLEAN AREA OF PAINT, ETC...
- 2) REMOVE EXISTING D2325 GUSSET(S) AS SHOWN IN FIGURE 1.
- 3) INSTALL REPLACEMENT D3929-041/-042 GUSSETS BY T.I.G. WELDING PER MIL-STD-2219/AMS-STD-2219 CLASS 'C' USING ER308L FILLER ROD AS SHOWN IN FIGURE 2.
- 4) TOUCH UP PAINT IN ACCORDANCE WITH ICA-D350-607 REV 0.
- 5) WHEN BASKET BASE IS REPAIRED, LONGER BOLTS OR QUICK RELEASE PINS ARE REQUIRED TO INSTALL THE BASKET ON AIRCRAFT. SUBSTITUTE EXISTING HARDWARE USING PARTS LISTED BELOW.
- 6) ADJUST WEIGHT AND BALANCE IN ACCORDANCE WITH THE TABLE ON SHEET 4.

### PARTS LIST

QTY. -011	QTY. -013	PART NUMBER	DESCRIPTION
X		DSI 9342-011	GUSSET REPAIR KIT
	X	DSI 9342-013	GUSSET REPAIR KIT, QUICK RELEASE
2	2	D3929-041	GUSSET ASSY, LH
2	2	D3929-042	GUSSET ASSY, RH
4		AN4-15A	BOLT (REPLACES AN4-12A)
8		AN960JD416	WASHER
	4	BLRS-020	QUICK RELEASE PIN (REPLACES BLRS-010)
4		MS21042L4	NUT

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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

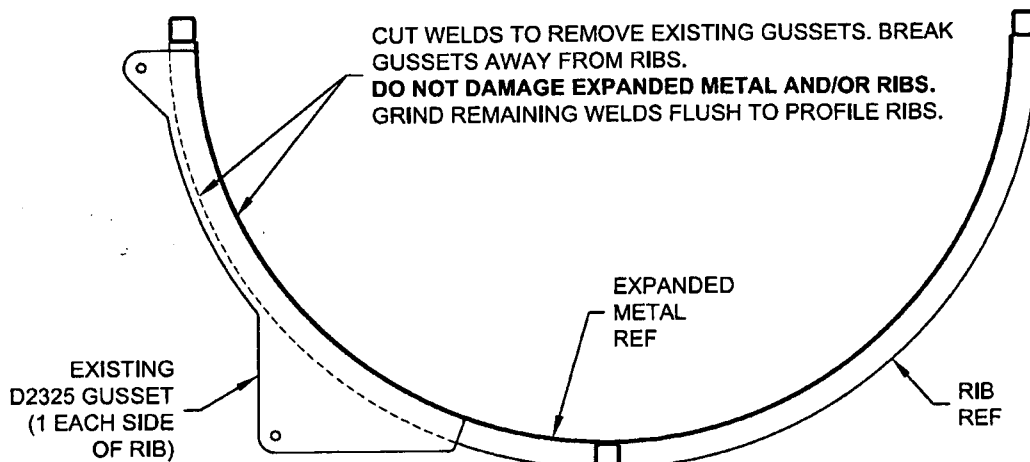
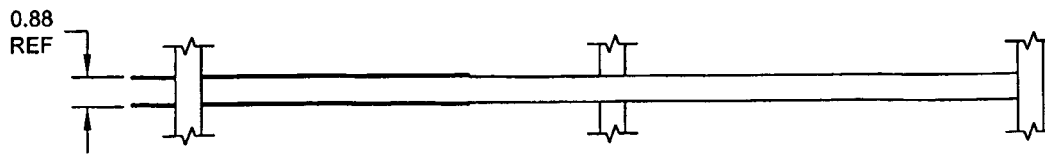
APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.04.06  
CERT. NO.: SH94-14  
ISSUE NO.: 4

B	CREATION OF DSI KITS TO PROVIDE REPLACEMENT PARTS AND REQD HARDWARE. SEE NCR#09-042.	MB	09.04.06
A	NEW ISSUE	PH	06.07.10
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	B		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9342	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BASKET BASE WELD REPAIR	NTS
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**FIGURE 1 - REMOVAL OF EXISTING D2325 GUSSETS**  
 (ON D350-607-041/-043 ONLY)

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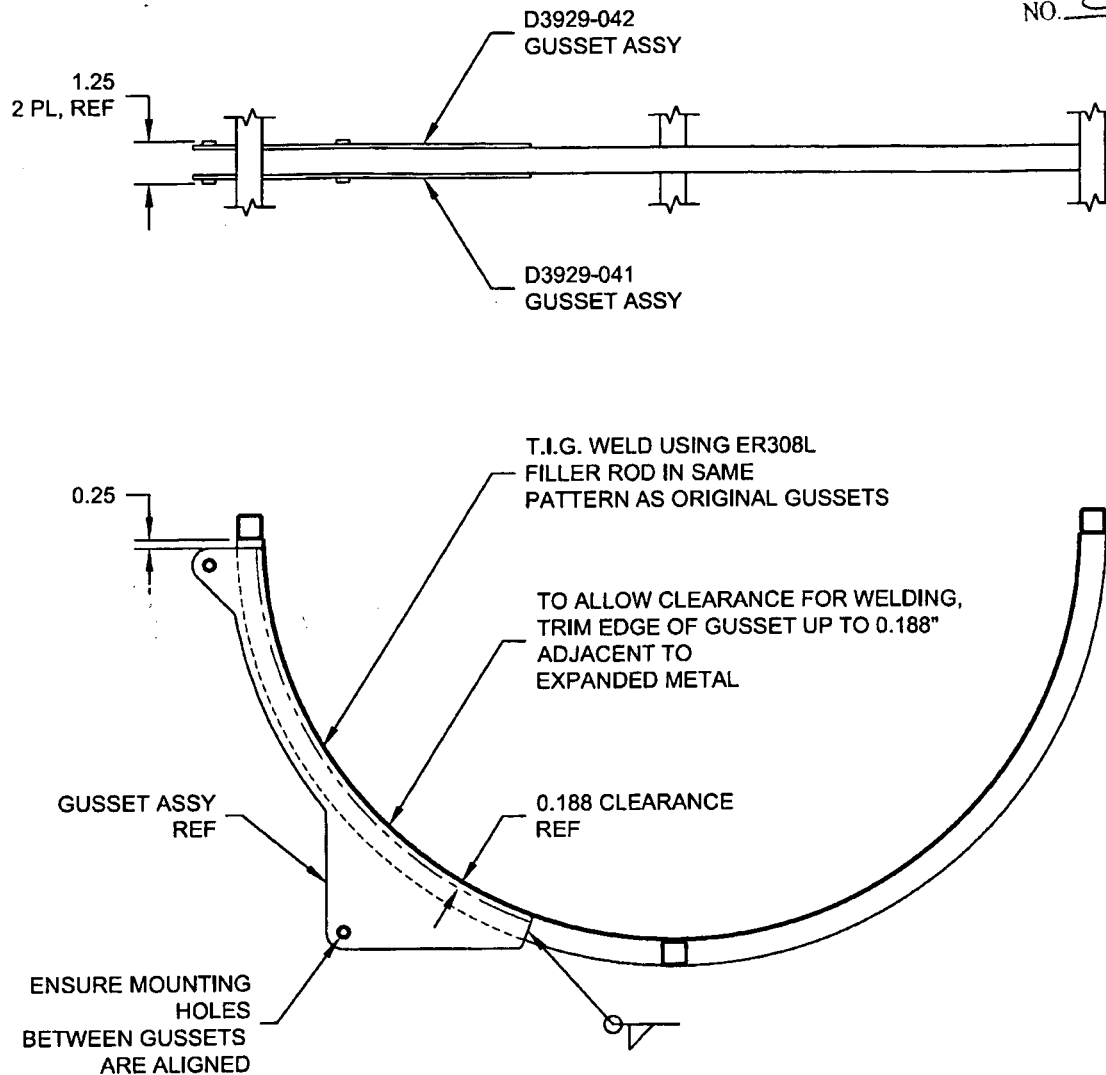
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MFG. APPR.	N/A	DSI 9342	SHEET 2 OF 4
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**FIGURE 2 - INSTALLATION OF REPLACEMENT D3929-041/-042 GUSSETS**  
(ON D350-607-041/-043 ONLY)

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MFG. APPR.	N/A	DSI 9342	SHEET 3 OF 4
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FOR D350-607-041 AT CHG 008, D350-607-043 AT CHG 005, AND D350-607-045/-047 AT CHG 003 AND SUBSEQUENT, THE INTENT OF DSI 9342 HAS BEEN INCORPORATED DURING MANUFACTURE. AMEND WEIGHT AND BALANCE AS OUTLINED BELOW. ALSO, THE PARTS LIST HAS BEEN AMENDED AS FOLLOWS:

QTY. -041	QTY. -043	QTY. -045	QTY. -047	PART NUMBER	DESCRIPTION
X				D350-607-041	HELI-UTILITY BASKET
	X			D350-607-043	HELI-UTILITY BASKET
		X		D350-607-045	HELI-UTILITY BASKET (SHORT)
			X	D350-607-047	HELI-UTILITY BASKET (SHORT)

**IS:**

1	1	1	1	AN4-12A	BOLT
4	4	4	4	AN4-15A	BOLT
28	40	30*	42*	AN960JD416	WASHER

\*: EXTRA WASHERS REQUIRED TO MOUNT LID ON BASE DUE TO INCREASED THICKNESS OF GUSSETS AT BOTH ENDS OF BASKET BASE. LOCATE WASHERS BETWEEN BASE HINGE PLATE AND D2022-101 SPACER, TYPICAL BOTH ENDS.

**WAS:**

5	5	5	5	AN4-12A	BOLT
28	40	28	40	AN960JD416	WASHER

**WEIGHT & BALANCE**

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D350-607-041/-043 AT CHG 008/005 HELI-UTILITY BASKET	89.6 lb 40.6 kg	±48 in ±1.22 m	±4301 in-lb ±49.5 m-kg	135 in 3.43 m	±12096 in-lb ±139.3 m-kg
D350-607-045/-047 AT CHG 003 HELI-UTILITY BASKET (SHORT)	66.6 lb 30.2 kg	±48 in ±1.22 m	±3197 in-lb ±36.8 m-kg	135 in 3.43 m	±8991 in-lb ±103.6 m-kg

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MFG. APPR.	N/A	DSI 9342 SHEET 4 OF 4
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